

# Work Order ID 64434

Monday, December 06, 2010 10:14:56 AM



Page 1

Item ID: D2600-3-BENT

Accept



Setup Start



Revision ID:

Item Name: Extrusion Bent

Stop



Start Date: 12/6/2010 Start Qty: 20.00



Cust Item ID:

Required Date: 12/13/2010 Req'd Qty: 20.00



Customer:

Reference:

Approvals: Process Plan: MF

Date: 10-12-06

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D2600

Rev D1

D2750

F

100

0.00



BENDING MACHINE - SKIDTUBES

CNC Bend I

Memo

0.00

CNC Delta 100 Bender

Pick qty 1 D2600-3-120 extrusion

1-Deburr one end of extrusion

2-Bend using CNC bending machine as per program 2750.C and Folio 14 use bending aid DT9635

3- cut fwd end of tube as per dwg D2750

4- cut aft end of tube as per dwg D2750

110

0.00



QCS- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control



10-12-6 (10)

BE (10) 10-12-06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 64434**

Monday, December 06, 2010 10:14:56 AM



Page 2

Item ID: D2600-3-BENT

Accept



Setup Start



Revision ID:

Item Name: Extrusion Bent

Stop



Start Date: 12/6/2010 Start Qty: 20.00



Cust Item ID:

Required Date: 12/13/2010 Req'd Qty: 20.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

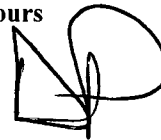
Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120

Identify as per dwg &amp; Stock Location: 46

0.00



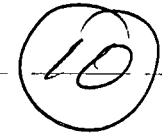
Packaging

Memo

0.00

Packaging

10-12-6



130

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/12/07

u 10.12.07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Monday, December 06, 2010 10:15:00 AM

Page 1

Work Order ID: 64434

Parent Item: D2600-3-BENT

Parent Item Name: Extrusion Bent




Start Date: 12/6/2010

Required Date: 12/13/2010

Start Qty: 20.00

Required Qty: 20.00

## Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2600-3-120  Extrusion Round 3" 350		Manufactured	No			100	Each	62.0000	1	20			

### Location

LG

43960

58480

### Loc Qty

62

24

38

### Loc Code

10

10-12-6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2600	REV. D SHEET 1 OF 5
DATE 98.08.20		TITLE EXTRUSION	SCALE 1:1
A	97.01.21	NEW ISSUE	
B	97.09.09	CHANGE MATERIAL SPEC.	
C	98.04.16	ADD D2600-3, UPDATE D2600-1 WIDTH, ADD DIE NO.	
D	98.08.20	INCREASE MIN. UTS TO 40 KSI	
DI	01.04.17	ADD PART NUMBERS & DIE NUMBERS <i>40</i>	

RELEASED  
98.08.25 DS

### GENERAL NOTES

1. MATERIAL: 6061-T6 (QQ-A-200/8)

MINIMUM YIELD TENSILE STRENGTH = 35 ksi  
MINIMUM ULTIMATE TENSILE STRENGTH = 40 ksi  
MINIMUM ELONGATION = 8 %

A SAMPLE FROM EACH BATCH WILL BE PULL TESTED  
TO ASTM STANDARD B221 BY AN APPROVED TESTING  
FACILITY TO ENSURE THAT THE BATCH MEETS THE  
ABOVE MINIMUM MECHANICAL PROPERTIES.

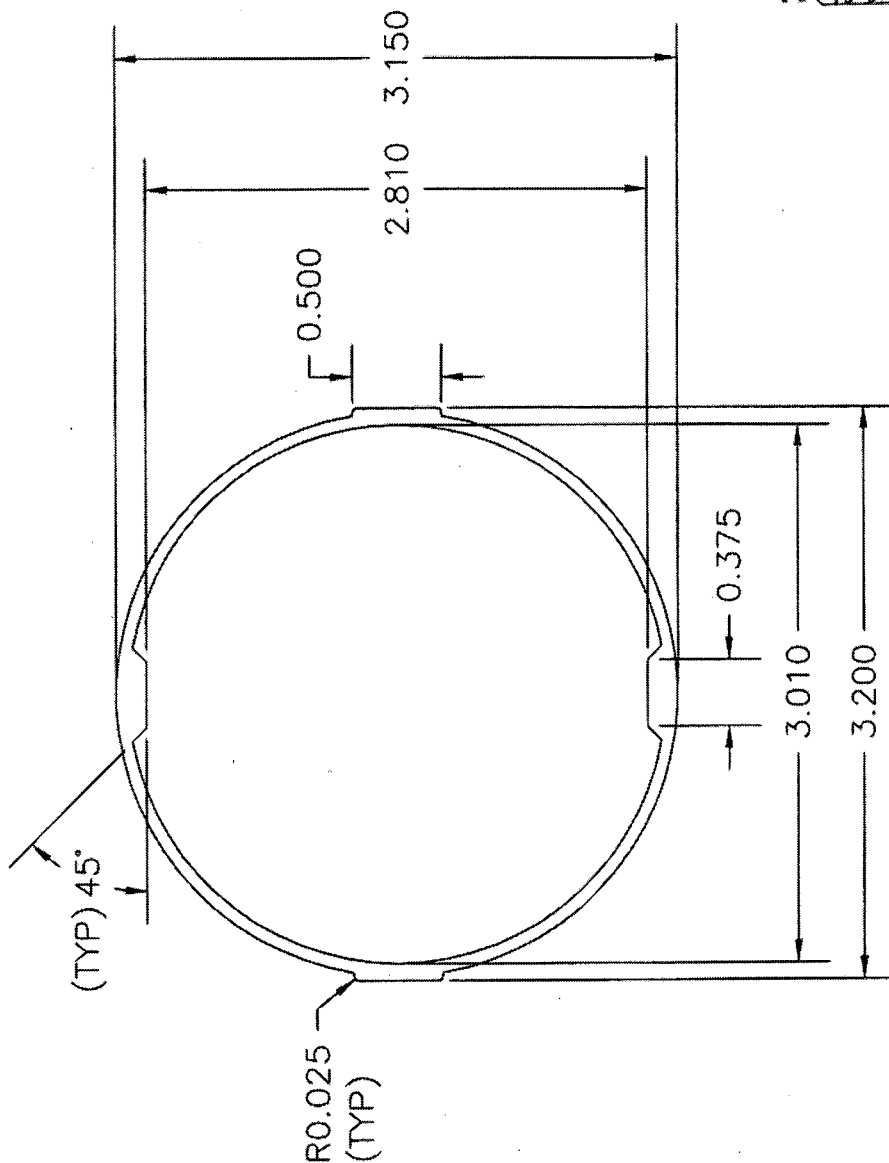
2. BREAK ALL SHARP CORNERS 0.010 MAX.
3. NO TOOLING MARKS.
4. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE  
NOTED.
5. ALL DIMENSIONS ARE IN INCHES.

*#64434*



DESIGN <i>DP</i>	DRAWN BY <i>DP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>DP</i>	DRAWING NO. D2600	REV. D SHEET 2 OF 5
DATE 98.08.20		TITLE EXTRUSION	SCALE 1:1

RELEASED  
98.8.25 DS



D2600-1

MANUFACTURED WITH CARADON INDALEX DIE # MH-18870  
OR BON L DIE # 897121 (PREFERRED CHOICE)  
PART NUMBER IS D2600-1-XXX WHERE XXX IS CUT LENGTH IN INCHES (EG. D2600-1-160 IS 160" LONG)



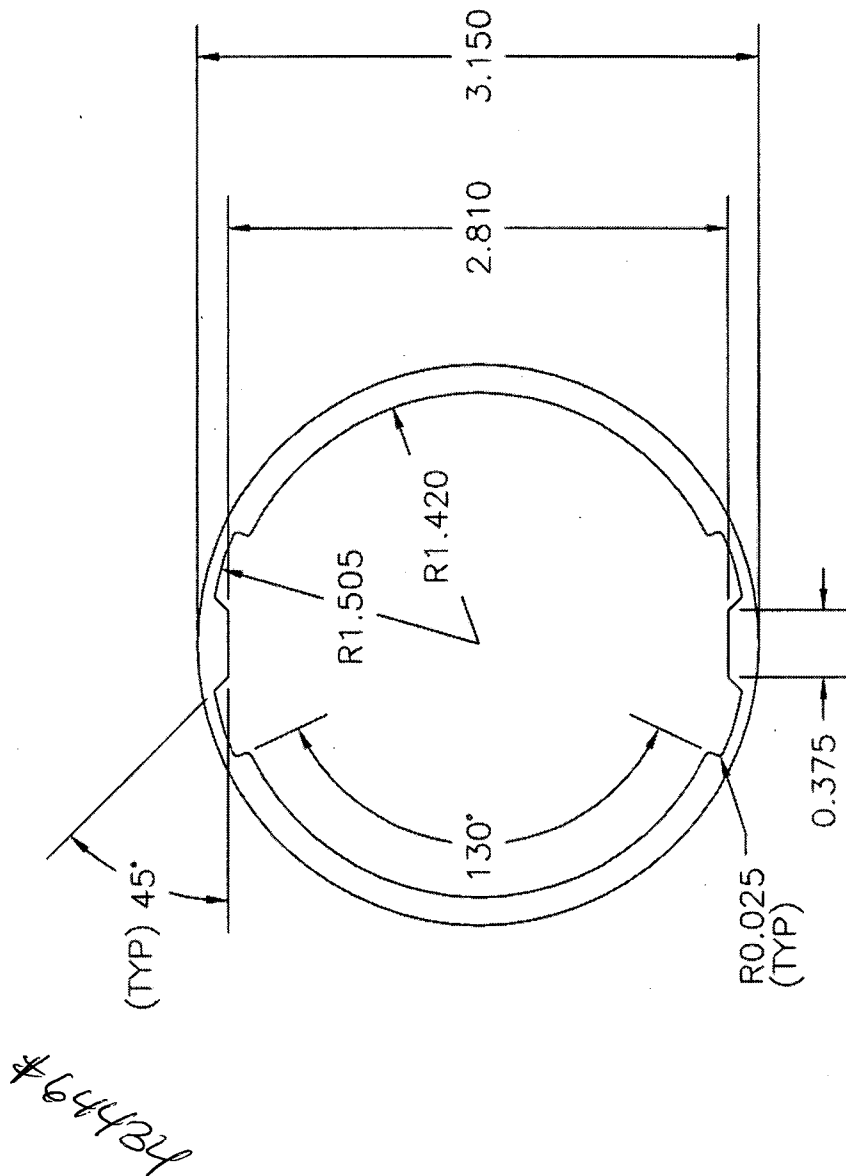
#164434





DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2600	REV. D SHEET 3 OF 5
DATE 98.08.20	TITLE EXTRUSION		SCALE 1:1

RELEASED  
98.8.25 DS



D2600-3

MANUFACTURED WITH CARADON INDALEX DIE # MH-18859

OR BON L DIE # 897122 (PREFERRED CHOICE)

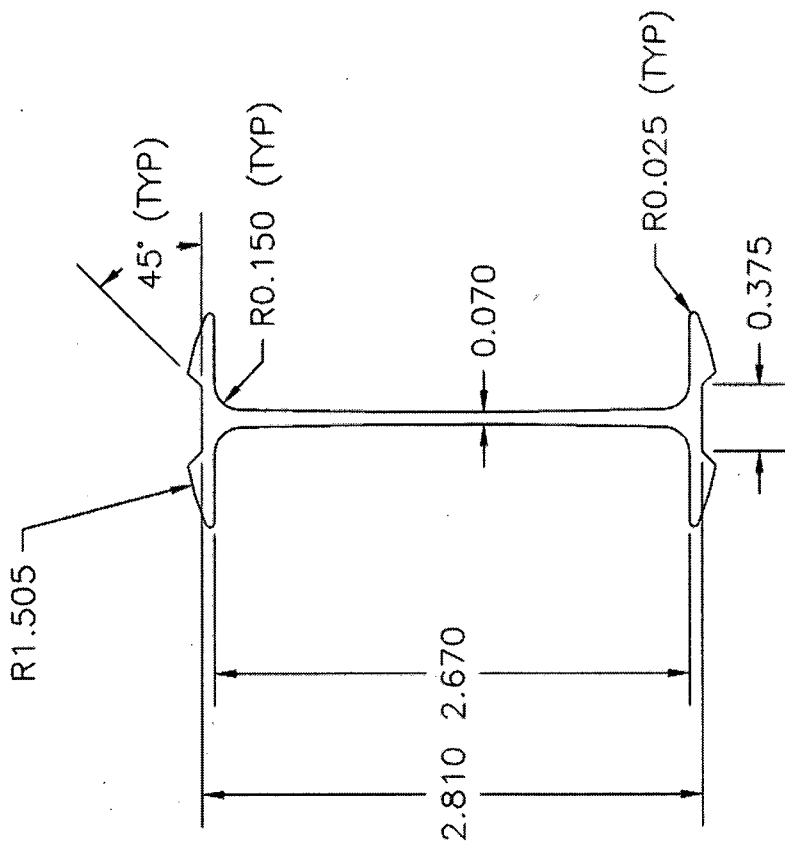
PART NUMBER IS D2600-3-XXX WHERE XXX IS CUT LENGTH IN INCHES (EG. D2600-3-120 IS 120" LONG)





DESIGN <i>MB</i>	DRAWN BY <i>MB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>KE</i>	DRAWING NO. D2600	REV. D SHEET 4 OF 5
DATE 98.08.20		TITLE EXTRUSION	SCALE 1:1

RELEASED  
98.8.25. DS



D2600-5

MANUFACTURED WITH CARADON INDALEX DIE # MS-18871  
PART NUMBER IS D2600-5-XXX WHERE XXX IS CUT LENGTH IN INCHES  
(EG. D2600-5-108 IS 108" LONG)

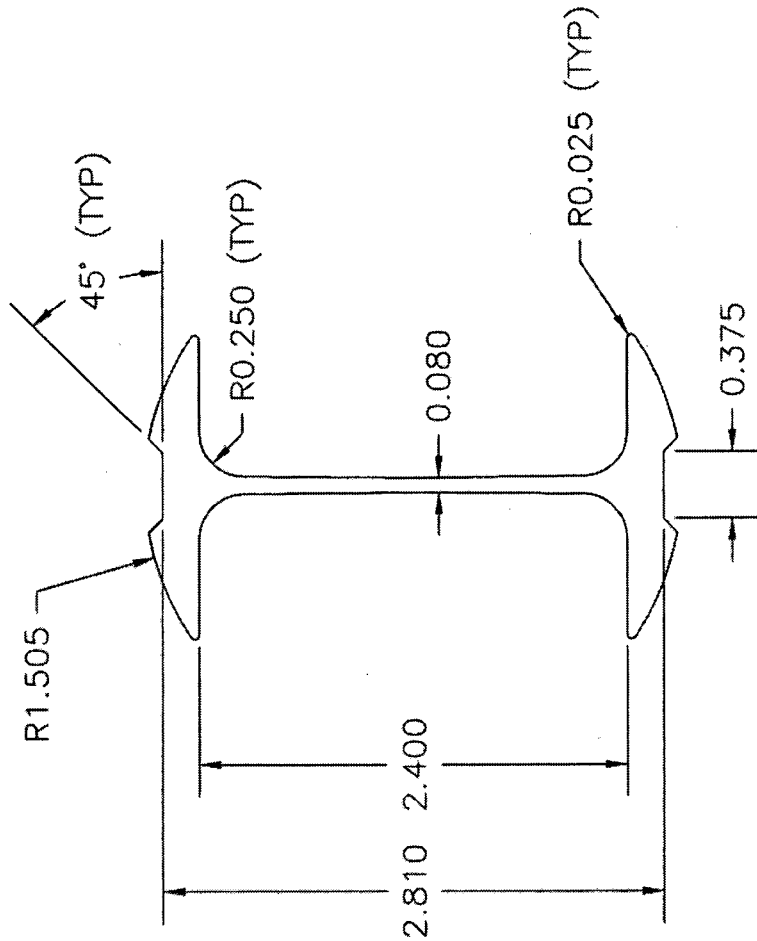


#64434



DESIGN <i>KE</i>	DRAWN BY <i>JS</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>JS</i>	DRAWING NO. D2600	REV. D SHEET 5 OF 5
DATE 98.08.20		TITLE EXTRUSION	SCALE 1:1

RELEASED  
98.8.25 DS



D2600-7

MANUFACTURED WITH CARADON INDALEX DIE # MS-18872  
PART NUMBER IS D2600-7-XXX WHERE XXX IS CUT LENGTH IN INCHES  
(EG. D2600-7-125 IS 125" LONG)



#64734